

# Work Order ID 99252

Thursday, April 04, 2013 10:03:46 AM

\*99252\*

Page 1

Item ID: D4780-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 4/4/2013 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 4/5/2013 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: *UMP*

Date: 13-4-4 Tooling:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4780

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4780-1 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

6061.032

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*1348*

*4*

*Jm13-4-8*

*Jm13-4-8*

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Revision ID:

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Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 4/4/2013 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 4/5/2013 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Bend as per dwg  
NC BRAKE

0.00

\*130\*

Brake NC

Memo

0.00

Brake NC

140

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

13.4.9

4

FF 13-04-09

SB 3/04/09

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Item ID: D4780-041

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**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Cover Mounting Bracket Assembly

Stop **\*NS2\***

Start Date: 4/4/2013 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 4/5/2013 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

4 76 13-4-10

165

QC7-Inspect Chemical Conversion Coat

0.00

**\*165\***

QC

Memo

0.00

Quality Control

4X4 m-f 13/04/10

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*170\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-30  
320°F  
9-00

4X4 m-f 13/04/10

M125069

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Item ID: D4780-041  
Revision ID:  
Item Name: Fwd Cover Mounting Bracket Assembly

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Start Date: 4/4/2013 Start Qty: 4.00 **\*4\***  
Required Date: 4/5/2013 Req'd Qty: 4.00 **\*4\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

H  $\phi$  13-11-10



190

0.00

**\*190\***

Small Fab

Memo

0.00

Small Fab

1- Install nutplate as per dwg

FF 13-04-10

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

Sm<sup>D</sup>  
13-4-10

4

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Item ID: D4780-041

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 4/4/2013 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/5/2013 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

210

Identify as per dwg &amp; Stock Location

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

MF 13-4-10

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

13/4/10 JG  
MF 13-4-10

# Picklist Print

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Work Order ID: 99252

Parent Item: D4780-041

Parent Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 4/4/2013

Required Date: 4/5/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	1,038.8000	0.0722	<del>0.304</del> 0.5			

Jm 13-4-8

## Location

## Loc Qty

## Loc Code

MAT021

1038.8

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

66.05

123293

58.5

123483

260.6

123701

52.95

124629

227.58

124629

MS20426AD3

RIVET

Purchased

No

Each

22,299.000

16

## Location

## Loc Qty

## Loc Code

ST333

299

123021

195

123352

104

ST334

8000

123164

8000

ST505

8000

124814

8000

ST509

6000

124586

6000

FF 13-04-10

16

# Picklist Print

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Work Order ID: 99252

Parent Item: D4780-041

Parent Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 4/4/2013

Required Date: 4/5/2013

Start Qty: 4.00

Required Qty: 4.00

MS21059L3

Purchased

No

Each

179.0000

8

Nut Plate

Location

Loc Qty

Loc Code

ST316

67

124291

67

ST506

112

124308

112

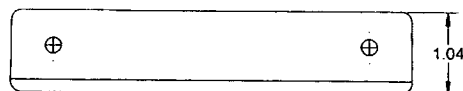
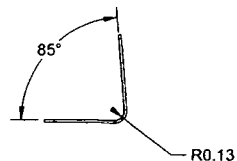
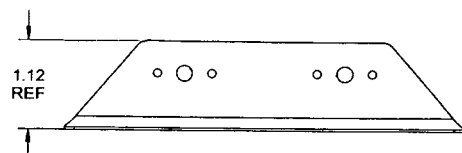
FF 13-04-10

8

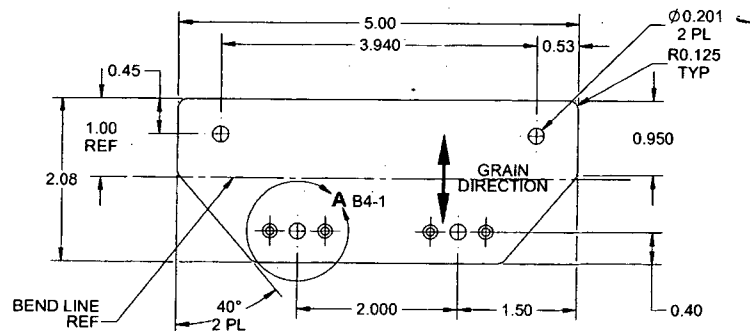
Thursday, April 04, 2013 10:03:46 AM

Shop Packet Print

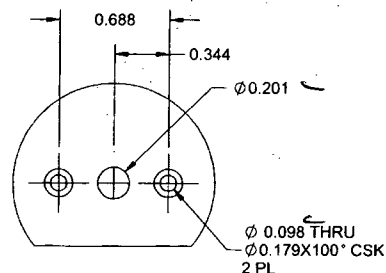
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**D4780-1 FWD COVER MOUNTING BRACKET**  
(MAKE FROM D4780-1F)



**D4780-1F FLAT PATTERN**



**DETAIL A B7-1**  
SCALE 2X  
2 PL

D4780-1 FWD  
COVER MOUNTING BRACKET

MS20426AD3-4 RIVET  
2X, 2 PL

MS21059L3  
NUTPLATE  
2 PL

**D4780-041 FWD COVER MOUNTING BRACKET ASSY**

RELEASED  
2013-03-11

QTY -041	P/N	DESCRIPTION
X	D4780-041	FWD COVER MOUNTING BRACKET ASSY
1	D4780-1	FWD COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4780-1F: NONE, D4780-041: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3, D4780-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4780-041" AND B/N USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4780-1F-REVA.DXF"

A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. A
MFG. APPR.	DB	D4780	SHEET 1 OF 1
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	FWD COVER MOUNTING BRACKET ASSY	NTS
DATE	13.03.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



